

ABSTRACT OF THE DISCLOSURE

A chip removal method removes residue such as chips that have remained in and adhered to an interior of a bag-shaped machined hole in a work piece. After air is jetted 5 out and blown against a bottom portion of the machined hole by using an air blow nozzle to change a flow of air that is circulating inside a nozzle into a spiral flow that moves in a direction towards the bottom portion of the machined hole, this spiral flow then blows upwards like a tornado from a vicinity of the bottom portion of the machined hole in a direction towards an aperture portion of the machined hole so that the residue inside the 10 machined hole is uplifted by the spiral flow and removed.